

Date: Friday, 05/09/2008 10:07:02 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM
Job Number :	41854		
Estimate Number :	10145		
P.O. Number :		Part Number :	D2037101
This Issue :	05/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2037 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	41316A03	Drawing Revision :	D
	Type :	Material :	
	SMALL / MED FAB	Due Date :	30/09/2008
Written By :		Qty:	10
Checked & Approved By :	<u>JLD 08.9.05</u>	Um:	Each
Comment :	Est Rev:A New Issue 05-11-01 JLM Est Rev:B 08-07-29 revD as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 4.1118 f(s)/Unit Total : 41.1180 f(s)

Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)

Batch: M108498 (6)

M109115 (2)

M109314 (2)

SB 08/10/14 (10)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SB 08/10/14 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

SB 08/10/16 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/10/17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:07:02 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41854

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 241A

8/10/17

SF

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2037-101 ARM

RELEASED
68 07 07 1420

NOTES:

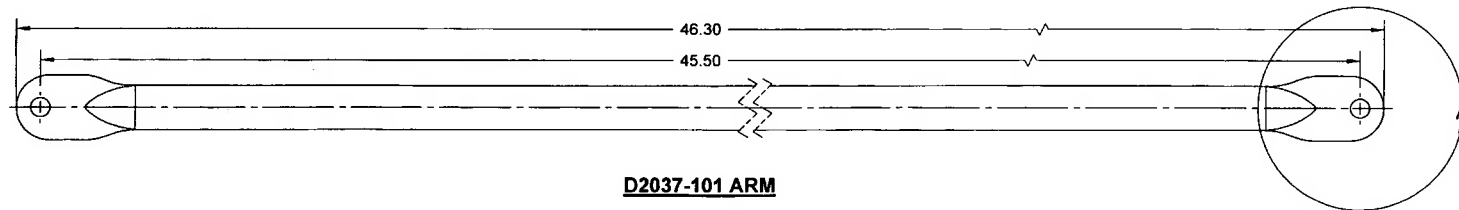
1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, $\phi 0.750 \times 0.049$ WALL
REF. DART SPEC M304TR0.750V.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs

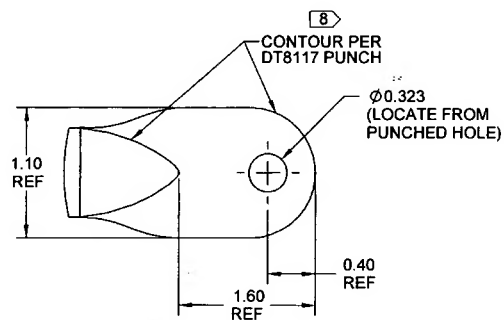
FOR FURTHER INFO SEE DRAWING D2638.

D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 1 OF 2
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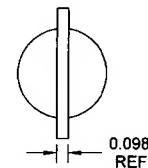
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D2037-101 ARM



DETAIL A
SCALE 2X
2 PL



RELEASED
06-07-01 WAD

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
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